

**Work Order ID 75832**

November-01-11 8:22:57 AM

**\*75832\***

Page 1

Item ID: D3272-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Step

Stop

**\*NS2\***

Start Date: 01/11/2011 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: M.L.SDate: 11/11/01

Tooling:

Date:

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3272	Rev B
-------	-------

100 0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00

\*\*\*SQUARE ONE END BEFORE CUTTING OTHER END\*\*\*

*Red. 10.01* 8 *8* *8*

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

110 QC6- Inspect dimensions to drawing 0.00

**\*110\***

QC

Quality Control

Memo

0.00

*PC 11.11.01* *8x8*

Dart Aerospace Ltd

**WORK ORDER CHANGES**

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval	Approval
DATE	STEP					Chief Eng / Prod Mgr	QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE (NCR)**

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75832

\*75832\*

Page 2

November-01-11 8:22:57 AM

Item ID: D3272-1

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Step

Stop

\*NS2\*

Start Date: 01/11/2011 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

Identify as per dwg & Stock Location: W4

0.00

8 8

\*120\*

Packaging

Packaging

Memo

0.00

11/11/01

130

QC21- Final Inspection - Work Order Release

0.00

11/11/02 8

\*130\*

QC

Quality Control

Memo

0.00

MC  
11/11/01

## WORK ORDER CHANGES

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DATE	STEP							

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date &amp; initial all entries

# Picklist Print

November-01-11 8:23:02 AM

Page 1

Work Order ID: 75832

\*75832\*

Parent Item: D3272-1

\*D3272-1\*

Parent Item Name: Step

Start Date: 01/11/2011

Required Date: 02/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	66.0200	1	8			

\*D2622-120C\*

Step Extrusion

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	HALL	56.32	
	64409	6	
	68293	0.5	
	72131	49.82	8
	WA	9.7	
	46910	2	
	66970	7.7	

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DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TH</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04-*TH*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 20832 M.C.J  
 11/11/01

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## WORK ORDER CHANGES

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DATE	STEP									

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

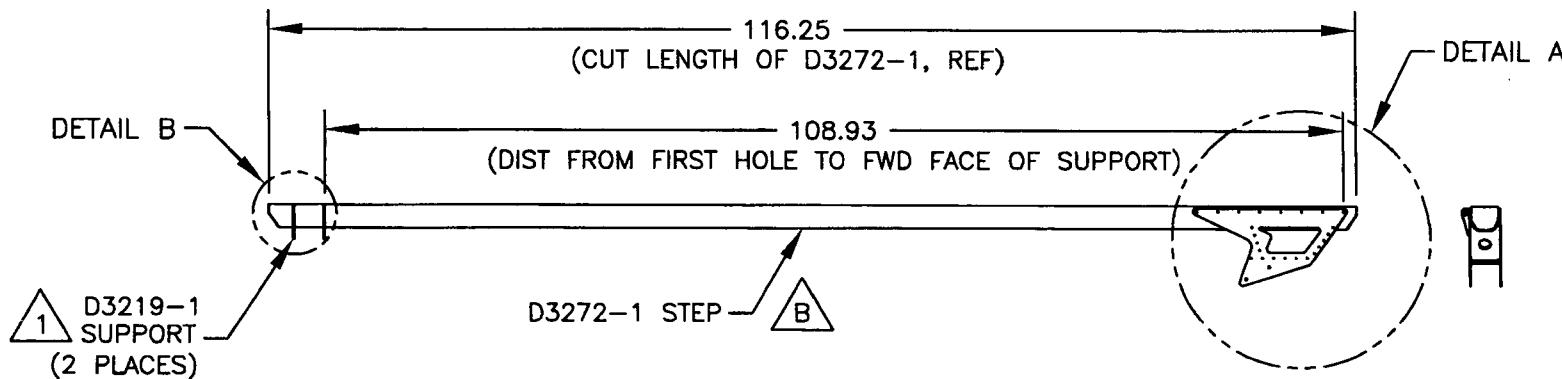
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

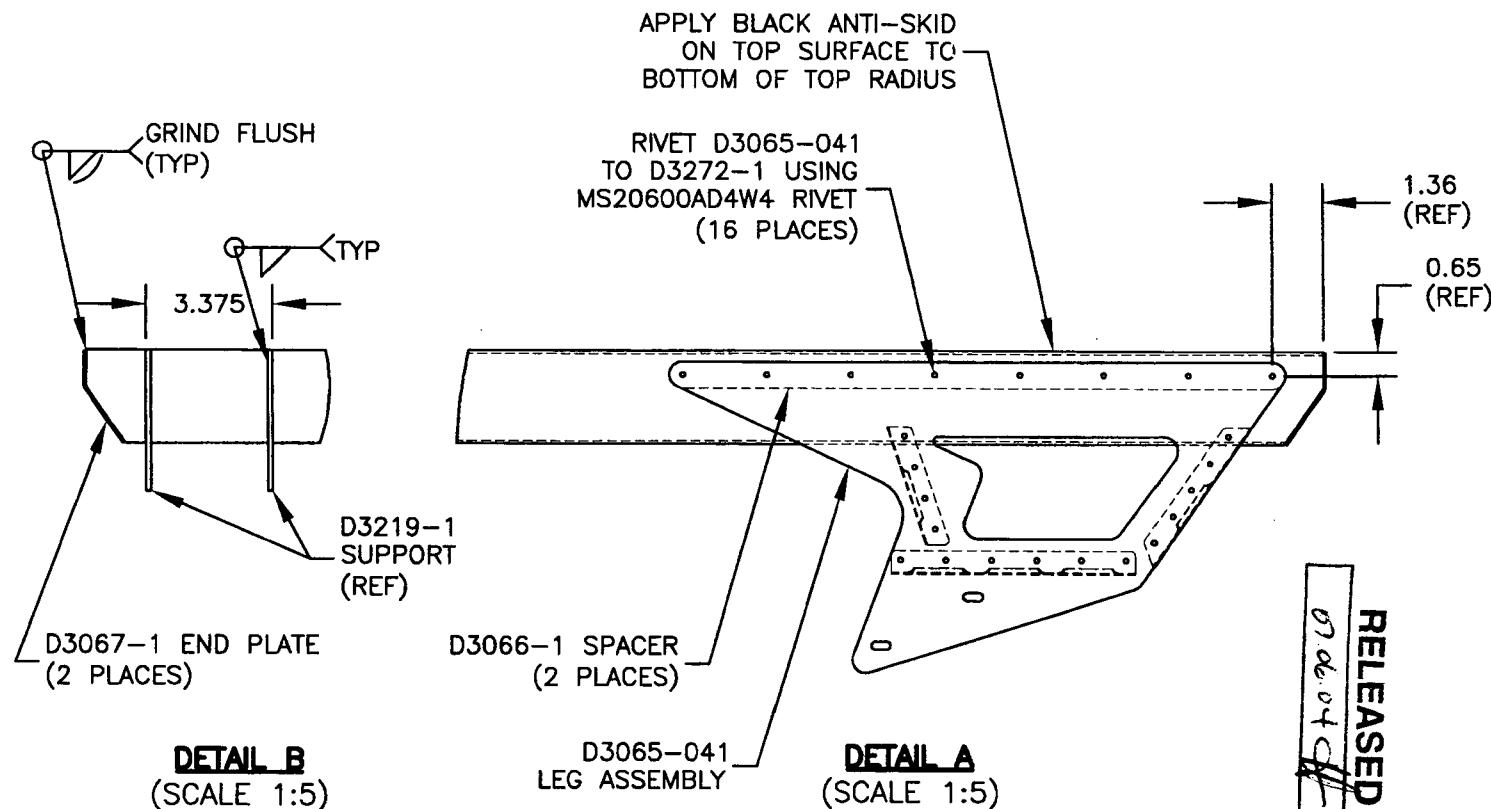
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NOTE: Date & initial all entries

75838



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASER  
07.06.04

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE		STEP ASSEMBLY, HI LONG
07.05.18		D3272
		REV. B SHEET 2 OF 3 SCALE 1:20

## WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval	Approval
DATE	STEP					Chief Eng / Prod Mgr	QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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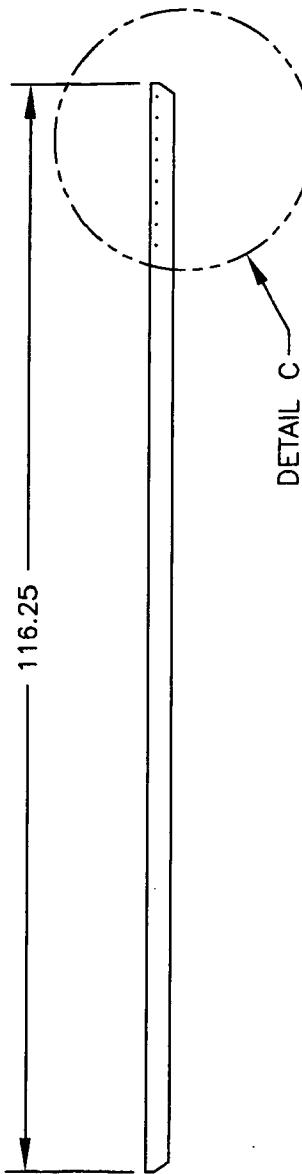
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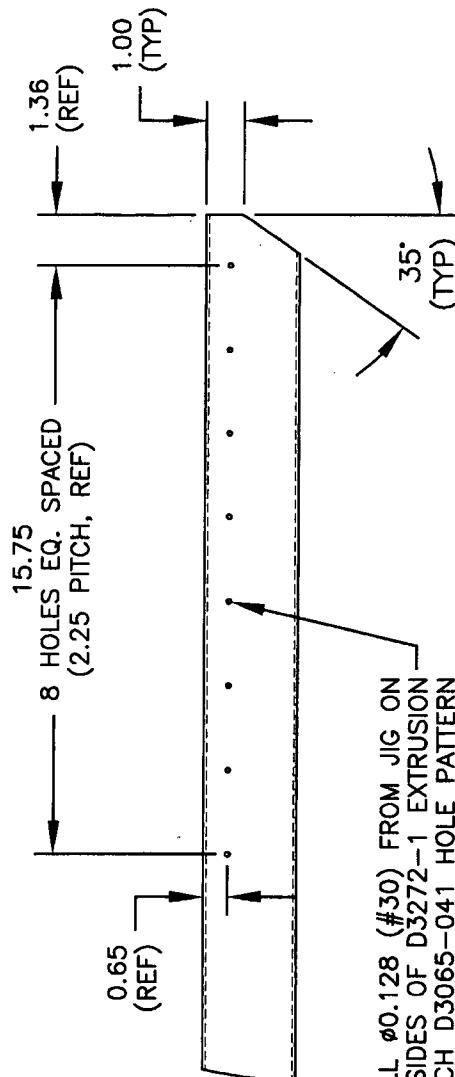
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**DART**

DESIGN <i>QP</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>ST</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



**D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



**DETAIL C**  
(SCALE 1:5)

**RELEASED**  
07.06.04 *ST*

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